












Date: Wednesday, 05/11/2008 3:24:27 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RH STEP ACTUATOR ASSEMBLY
Job Number : 43222	
Estimate Number : 12760	
P.O. Number :	Part Number : 41232 000 001 002
This Issue : 05/11/2008 S.O. No. :	Drawing Number : 41232-000-001 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : // Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 39168	Material :
Written By :	Due Date : 20/11/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 08.11.05</u>	
Comment : Est Rev:A New Issue 07-02-28 JLM	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation:
1.0	DC
DOCUMENT CONTROL	
 <u>JLD 08.11.11</u> 	
Comment: DOCUMENT CONTROL Photocopy bluefile D412-763 & type labels per PPP41232-000-001 CHG 002	
2.0	PACKAGING 1
PACKAGING RESOURCE #1	
 	
Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
3.0	AP0925ELBN
BARBED ELBOW	
 	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) BARBED ELBOW Batch: <u>M103683</u> SD	
4.0	AN960JD416
Washer	
 	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s) Washer Batch: <u>M108827</u> SD	
5.0	MS21042L4
Nut	
  (2x)	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Nut Batch: <u>M108145</u> 8/11/10 SD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	AN423A	Bolt
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M107378

SP

7.0	MS3548993	GROMMET
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

GROMMET

Batch: M106168

SP

8.0	AN960JD416L	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M109388

SP

9.0	MS24665151	Cotter Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cotter Pin

Batch: M14506

SP

10.0	MS203923C21	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pin

Batch: M104156

SP

11.0	R 3400	plastic tubing 1/4id x 3/8od-black
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Comment: Qty.: 3.0500 f(s)/Unit Total : 6.1000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch: M104229

SP

12.0	41232 200 006 001	Bracket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bracket

Batch: B30505

(2x)

SP

8/11/10

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0	41232 200 005 001	Spacer (Step Actuator)
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Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)
Spacer (Step Actuator)
Batch: B43253

54

14.0	41232 200 004 001	Reducer Tee Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Reducer Tee Assembly
Batch: M29779

50

15.0	41232 200 003 001	Spring (Step Actuator)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Spring (Step Actuator)
Batch: B30941

50

16.0	41232 200 001 002	Step Actuator RH Ass'y
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Step Actuator RH
Batch: 42219

21

50

17.0	124K002 4CR 0545	Hose ass'y-Step Actuator
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)
Hose ass'y-Step Actuator
BATCH: M104394

21

50

18.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

19.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location: 10

PPP Rev: 13

21

50

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/11/11

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



u 08/11-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

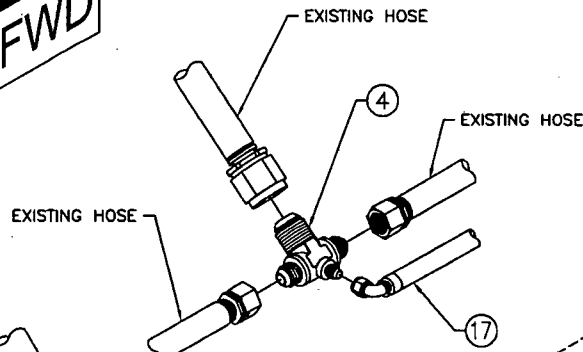
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

FWD



L/H STEP

L/H SKID TUBE

16 INSTALL ELBOW IN EXISTING SKID TUBE HOLE PREVIOUSLY USED FOR ELECTRICAL WIRE.
11
12

412-050-017-133 COVER (REF.)

17 EXISTING FLOAT BAG
ROUTE HOSE THROUGH FLOAT BAG ATTACHMENT ALONG SIDE OF EXISTING HOSE.

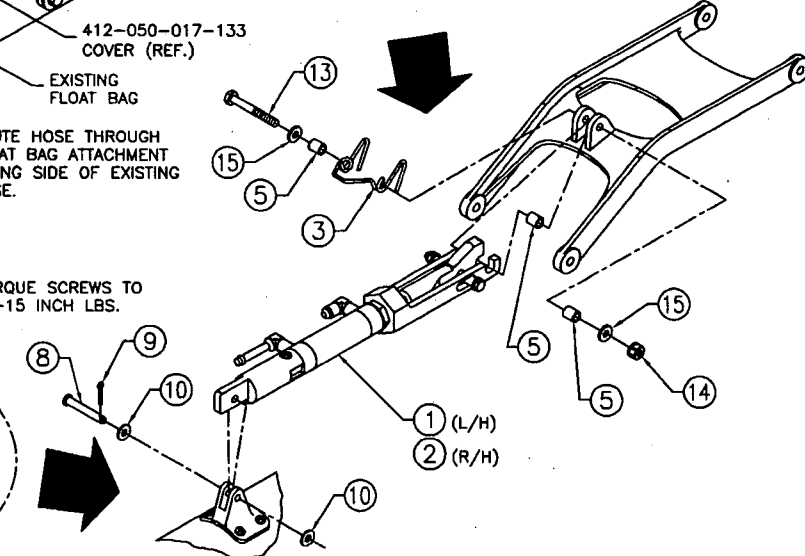
EXISTING HOSE
RETAINER (REF.)
17 SCREW (REF.)

TORQUE SCREWS TO 12-15 INCH LBS.

6 BRACKET MUST BE INSTALLED AS SHOWN

FWD

VIEW LOOKING INBOARD



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Era Aviation, Inc.

STEP ACTUATOR INSTALLATION

REV. C

41232-000-001
SHT 2 OF 2

REV. A

NO. 41232-000-001
WORK ORDER
WITHOUT NOTICE
UNCONTROLLED COPY
ENGINEER
RETURN
SHOP COPY
001 L/H INSTALLATION (SHOWN)
002 R/H INSTALLATION (OPPOSITE)
SUBJECT TO ATTENDMENT